

Work Order ID 92794

November-08-12 11:45:28 AM

92794

Page 1

Item ID: D412-664-203

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Crosstube Aft

Start Date: 11/08/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/08/12 Req'd Qty: 1.00

1

Customer:

Reference: Falcon return - scrap

Approvals: Process Plan: *u*

Date: Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D412-664-243

E/DEO

260

QC4- 100% Inspect kits for completeness

0.00

260

QC

Memo

0.00

Quality Control

inspect Falcon return
D412-664-203 B67434
scrap tube

Tube given to cng.

8 12-11-08

280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Memo

0.00

Quality Control

u 12-11-09

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
	Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General		
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain	<input type="checkbox"/> Ovalized
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware	<input type="checkbox"/> Over/Under tolerance
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Part Incorrect
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Lost/Missing
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance	<input type="checkbox"/> Part Moved
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Positioned Wrong
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread	<input type="checkbox"/> Power Loss/Surge
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset	<input type="checkbox"/> Pressure/Forced
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration	<input type="checkbox"/> Temperature/Cure
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Weld
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Wrong Stock Pulled
			<input type="checkbox"/> Other

Picklist Print

November-08-12 11:45:28 AM

Page 1

Work Order ID: 92794

Parent Item: D412-664-203

Start Date: 11/08/12

Required Date: 11/08/12

Parent Item Name: Crosstube Aft

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:E04.02.16Reformat; Added D3189-1K/DS
 IPP Rev:F 06-03-29 Remove Coments on Pick List JLM
 IPP Rev:G 06.12.08 per ECN 886 EC
 IPP Rev:H 07-04-30 As per Rev D JLM
 IPP Rev:I 08-06-12 add comment in seq. 21 DD verified by:EC IPP rev J 11.04.21 DEO D412-664-243-E-1 EC verified DD IPP REV:K 11.10.03 DEO D412-664-243-E-2 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D412-664-203

Manufactured

No

Each

7.0000

1

Crosstube Aft

Location

Loc Qty

Loc Code

FG

2

87296

1

89417

1

FG103

4

89183

1

89184

1

89185

1

89416

1

Return2012

1

67058

1

67434

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabelled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

92794

Work Order ID 67434

Monday, March 21, 2011 9:44:53 AM



Page 1

Item ID:	D412-664-203	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Crosstube Aft					
Start Date:	3/21/2011	Start Qty:	1.00			
Required Date:	3/25/2011	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:	<u>11</u>	Date:	<u>11-03-21</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D412-664-243	E								

100
 DOCUMENT CONTROL
DC
Document Control
Memo
Photocopy bluefile and create labels as per PPP D412-664-203 CHG 006
0.00
0.00
Sublot 1
12-11-09
HCB BG 11-4-4

110
 Packaging
Packaging
Packaging
Memo
0.00
0.00
11-3-28

120
 BENDING MACHINE - CROSSTUBES
CNC Bend 2
CNC Alpha 160 Bender
Memo
Bend tube as per Dwg D412-664-243 using CNC bender program 412-af and Folio FT010
0.00
0.00
11-3-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67434

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Page 2

Item ID: D412-664-203

Accept



Setup Start



Revision ID:

Item Name: Crosstube Aft

Stop



Start Date: 3/21/2011 Start Qty: 1.00

Required Date: 3/25/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC15- Crosstube Dimensional Check

0.00



QC

Memo

0.00

Quality Control

8/103/79

Ⓢ

140

Crosstubes

0.00



Crosstubes

Memo

0.00

Crosstubes

1-Drill pilot holes in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551 and drill table DT8577 using #9 holes as per QSI 10 to install towers.

2-Ream hole to finish size in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-SCRIBE PART # & BATCH #

4-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243

B
BE 11/03/29

SAD 11-03-29

WORK ORDER CHANGES

W/O:								
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67434

Monday, March 21, 2011 9:44:53 AM

Page 3

Item ID: D412-664-203

Accept

Revision ID:

Item Name: Crosstube Aft

Start Date: 3/21/2011 Start Qty: 1.00

Required Date: 3/25/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Crosstubes Chemical Conversion

0.00



HandFXtube

Memo

0.00

SAO 11-03 29

D

Hand Finishing Crosstubes

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Sulor/31

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Sulor/31

Quality Control

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67434

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Page 4

Item ID: D412-664-203

Accept

Revision ID:

Item Name: Crosstube Aft

Start Date: 3/21/2011 Start Qty: 1.00

Required Date: 3/25/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180	Outsource process - NDT per QSI038 4.1	0.00							
Outsource2	Memo	0.00							
Outsource process - NDT	Liquid Penetrant Inspection as per QSI 038Or Issue P/O: <u>13743</u> LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order								

190	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Inspect for transit damage Ensure copy of NDT results attached to work order.								

200	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control	Inspect for damage & ensure results are as per Dwg D412-664-203								

11-03-30

11-03-30

11-03-30

Dart Aerospace Ltd

WORK ORDER CHANGES

W/O:								
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67434

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Page 5



Item ID: D412-664-203

Accept



Setup Start



Revision ID:

Item Name: Crosstube Aft

Stop



Start Date: 3/21/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210



SprayPaint

SprayPaint

0.00

Memo

0.00

Spray Painting

1-Prime inside and outside crosstube as per QSI 005 4.2
2-Paint outside crosstube with White Imron as per QSI 005 4.2

PRIME:

Start Time: 10 00

Finish Time: 11 00

PAINT:

Start Time: 3 00

Finish Time: 4 00

25 11-03-30

220



QC

Quality Control

QC14- Inspect Spray Paint

0.00

Memo

0.00

Then, Wrap in plastic bag to protect from scratches

11 03 31 (1)

Dart Aerospace Ltd

W/O: 67434		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11-03-31	210	grind off paint on inside of tube 2" wide staying 2" away from cuffs. re alodine ground areas prime ground area using tempo yellow epoxy primer	BT	11-03-31		MD 11/04/01	G. Stanley 11/04/01
		inspect	BT	11-04-01		MD 11/04/01	G. Stanley 11/04/01
		scuff + clean coat using imacon 5005	BT	11-04-01		MD 11/04/01	G. Stanley 11/04/01

Part No: D412-664-203 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67434

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Page 6

Item ID: D412-664-203

Accept

Revision ID:

Item Name: Crosstube Aft

Start Date: 3/21/2011 Start Qty: 1.00

Required Date: 3/25/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230



Crosstubes

Crosstubes

Crosstubes

Memo

Assemble as per Dwg D412-664-203

1- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe

2-Install supports with magnobond as per QSI 015 Adhere for 12 Hrs

A/R 6398 Magnobond Batch: 116677
Expiry Date: 03/20/11

3-Install clamps as per Dwg D212-664-203 using installation jig DT9024 with 0.010 thick brass shims on both chafing shield (D3189-1). Torque clamps to 80-100 in lb.

0.00

0.00

11 04 02 11
\$50

240



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Re measure by flipping tube
and support A is center
Sulayby

40

Dart Aerospace Ltd

W/O: 67434		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11-04-02	230	install chafing shields using Pro Seal P/S 890 B2 as per attached email	BT	11-04-02		MD 11/04/04	S 11/04/04

Part No: D412-664-203 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/04/04	230	Found that the center support is .100"-.125" off center to one side. Rt. maxes down position						S 11/04/04

NOTE: Date & initial all entries

Work Order ID 67434

Monday, March 21, 2011 9:44:53 AM

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Item ID: D412-664-203

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Revision ID:

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Start Date: 3/21/2011 Start Qty: 1.00

Required Date: 3/25/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

Pick Kit

0.00

Packaging

Memo

0.00

Packaging

260

QC4- 100% Inspect kits for completeness

0.00

QC

Memo

0.00

Quality Control

270

Packaging

0.00

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-664-203

*****Ensure tube is not packaged if curing time is less than 12 hrs, see step 27

for application time & date *****

Time & date of packaging:

Location: 103

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67434

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Item ID: D412-664-203

Accept

Revision ID:

Item Name: Crosstube Aft

Start Date: 3/21/2011 Start Qty: 1.00

Required Date: 3/25/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

u/4/4

MF

11-04-09

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 67434

Parent Item: D412-664-203

Parent Item Name: Crosstube Aft

Start Date: 3/21/2011



Required Date: 3/25/2011

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:E 04.02.16 Reformat; Added D3189-1 K/DS
 IPP Rev:F 06-03-29 Remove Comments on Pick List JLM
 IPP Rev:G 06.12.08 per ECN 886 EC
 IPP Rev:H 07-04-30 As per Rev D JLM
 IPP Rev:I 08-06-12 add comment in seq. 21 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D412-664-203TRN 		Manufactured	No			110	Each	0.0000	1	1			
Crosstube Turning Detail													
D2856-600 		Manufactured	No			230	f	125.9531	1.76	1.76			
Abrasion Strip													

B67457

DP

11-3-28

A - MC

11-04-04

D2896-1



Support

Manufactured No

230

Each

13.0000

1

1

11-04-02

Location

ST409

Loc Qty

125.9531

1.25

2.5

122.2031

Location

LG052

Loc Qty

13

47820

5

58356

8

Loc Code

X 1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, March 21, 2011 9:45:00 AM

Page 2

Work Order ID: 67434

Parent Item: D412-664-203

Parent Item Name: Crosstube Aft

Start Date: 3/21/2011

Required Date: 3/25/2011

Start Qty: 1.00

Required Qty: 1.00

D3189-1 Manufactured No

230

Each

26.0000

2

2



Chafing Shield

67587

67587



11-04-02

Pro Seal # M116544 exp: 04/2011 M.M.

Location

Loc Qty

Loc Code

FG

2

36065

2

LG053

24

58960

4

63982

20

D3595-063-570

Manufactured No

230

Each

54.0000

2

2



RUBBER CUSHION



11-04-02

Location

Loc Qty

Loc Code

FG

4

37971

4

LG055

50

42243

29

63406

21

MS21920-28

Purchased No

230

Each

86.0000

4

4



Clamp(per MIL-DTL-8783C)



11-04-02

Location

Loc Qty

Loc Code

FG

5

105884

5

LG050

75

116039

24

116839

51

LG051

6

114749

6

Monday, March 21, 2011 9:45:00 AM

Shop Packet Print

Page 2

1941-1942

1943

1944

1945

1946

1947

1948

1949

1950

1951

1952

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)				
DATE	STEP	Description of NC Section A	Corrective Action Section B		Verification Section C	Approval Chief Eng
			Initial Chief Eng	Action Description Chief Eng		

NOTE: Date & initial all entries

Picklist Print

Page 3

Monday, March 21, 2011 9:45:00 AM

Work Order ID: 67434

Parent Item: D412-664-203

Parent Item Name: Crosstube Aft

Start Date: 3/21/2011

Required Date: 3/25/2011

Start Qty: 1.00

Required Qty: 1.00

M521920-30

Purchased

No

230

Each

98.0000

2

2



clamp(per MIL-DTL-8783C)



11-04-02

Location

Loc Qty

Loc Code

LG050

48

109181

36

112772

12

LG051

50

111258

50

AN6-40A

Purchased

No

250

Each

75.0000



Bolt



11/4/48

Location

Loc Qty

Loc Code

ST343

75

112828

1

115300

34

115905

20

116549

20

AN6-41A

Purchased

No

250

Each

36.0000



Bolt



11/4/48

Location

Loc Qty

Loc Code

ST344

36

113288

6

115316

30

AN960JD616

NAS1149D0663J

Purchased

No

250

Each

0.0000

18

18



Washer



11/6/289

11/4/48

Monday, March 21, 2011 9:45:01 AM

Shop Packet Print

Page 3

WORK ORDER CHANGES

W/O:								
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, March 21, 2011 9:45:01 AM

Work Order ID: 67434

Parent Item: D412-664-203

Parent Item Name: Crosstube Aft

Start Date: 3/21/2011

Required Date: 3/25/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L6

Purchased

No

250

Each

207.0000

6

6

Nut

Location

Loc Qty

Loc Code

ST300

207

111578

4

116102

3

116373

100

116548

100

3
3

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

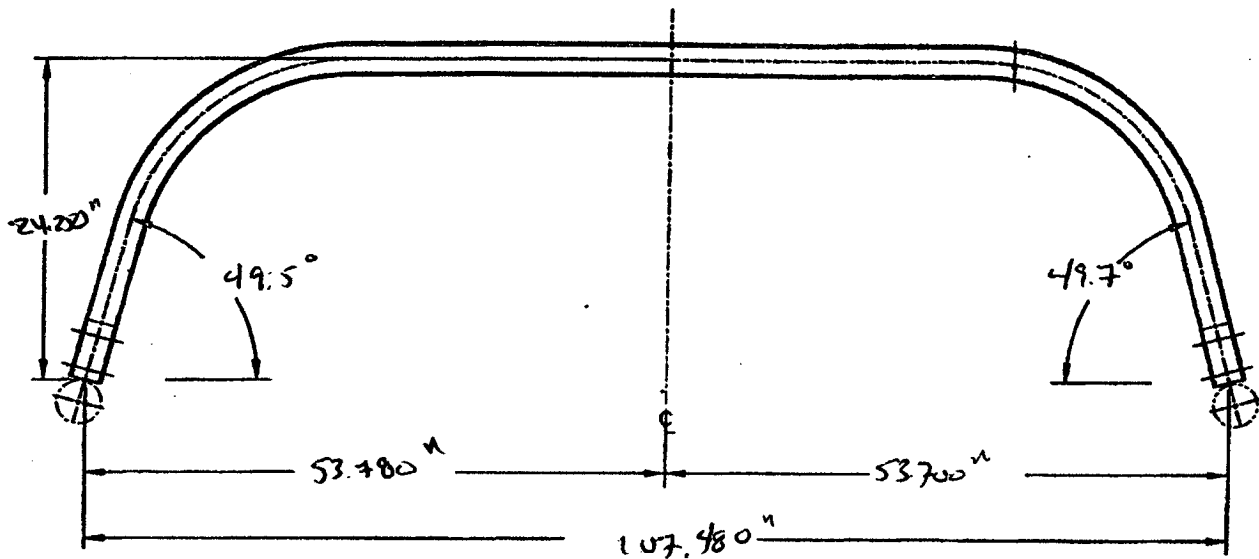
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	67484
Description: Crosstube High Aft (412)	Part Number:	D412-664-203
Inspection Dwg: D412-664-243	Rev: E	Page 1 of 1

Required Dimension	Min	Max
Height	24.24	24.50
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.70



Comments

QC15 Inspection	<i>[Signature]</i>
Date	11/03/07

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.05.08	Dimensions updated per Dwg rev. D	KJ/JLM	
C	10.02.02	Dwg Rev updated	KJ	<i>[Signature]</i>

Item	Qty -243	Part Number	Description
1	X	D412-664-243	CROSSTUBE ASSEMBLY (412 HIGH AFT)
2	1	D6009-129	CROSSTUBE
3	2	D3595-063-570	RUBBER CUSHION
4	1	D2896-1	SUPPORT
5	2	D3189-1	CHAFING SHIELD
6	2	D2856-600-1009	ABRASION STRIP
7	4	MS21920-28	CLAMP
8	2	MS21920-30	CLAMP (OR MS21920-32)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

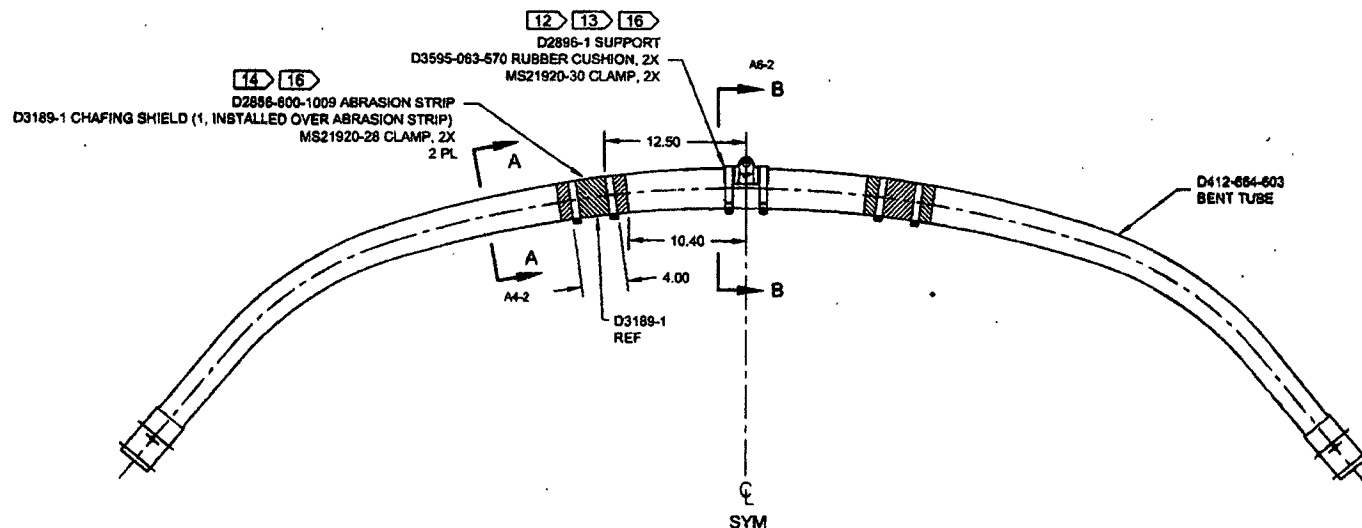
GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6009-129
FINISHED LENGTH = 124.100±0.020 (BEFORE BENDING/TRIMMING)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D412-664-243" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 47.0 lbs (PER IIN-D212-684)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2896-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-30 CLAMPS (OR -32) WITH D3595-063-570 RUBBER CUSHIONS TO SECURE THE D2896-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT.
- 14) INSTALL D2856-600-1009 ABRASION STRIPS WITH A 0.13 REF GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.
- 15) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 16) TORQUE CLAMPS 80 TO 100 IN.-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

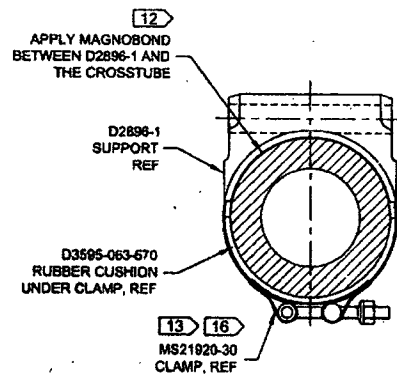
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *67434*
PL 1103-21

RELEASED
2009-10-29
WJP

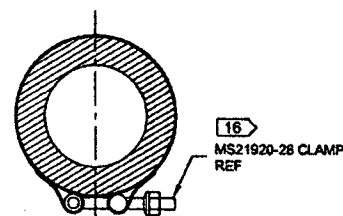
E	REFORMAT/REVISE GENERAL NOTES; REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; RELOCATED FLAG #6 PER PAR 08-046 (ZN A6-3); ADD TOLERANCE (ZN B6-3, C4-3, C8-3 & C5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	09.09.30
D	REMOVE D2732-058, CHANGE TO D3595-063-570	PH	07.03.09
C	REMOVE D2856-600-1087, ADD D2732-058 & MAGNOBOND 6398; MS21920-32 WAS MS21920-30	MB	06.10.27
B	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIOTUBES	PH	05.02.04
A	NEW ISSUE	PH	01.10.17
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>RF</i>		
CHECKED	<i>PH</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>PH</i>	D412-664-243	SHEET 1 OF 4
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	CROSSTUBE ASSEMBLY (412 HI AFT)	NTS
DATE	09.09.30	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.	



D212-664-243
ASSEMBLY DETAIL E



SECTION B-B D4-2
SCALE 4X

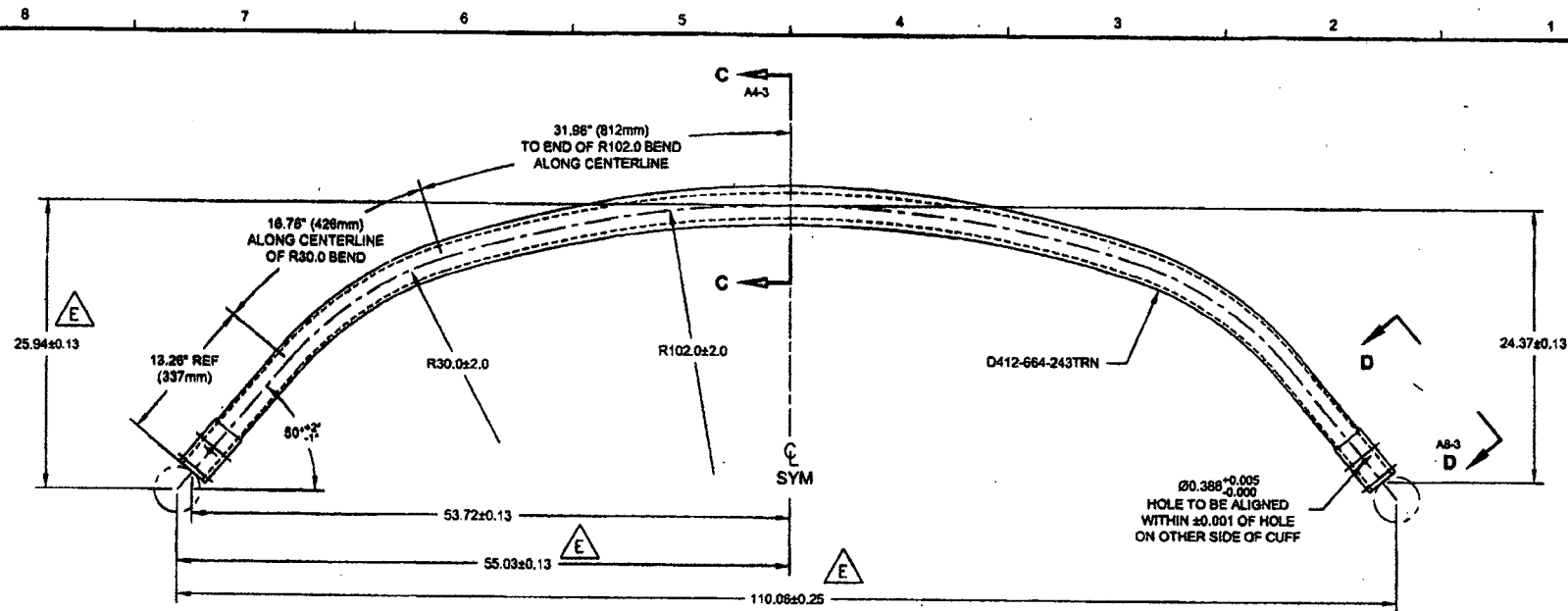


SECTION A-A C8-2
SCALE 4X

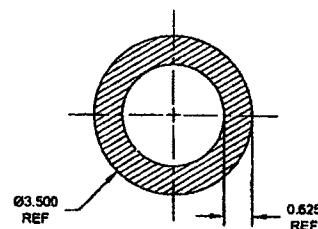
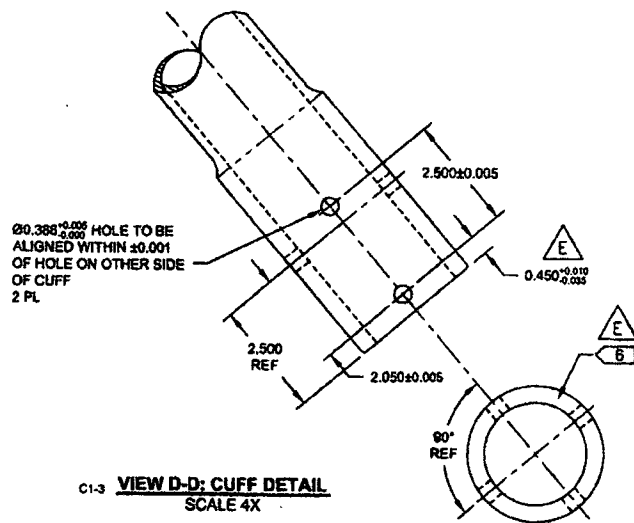
W602439

RELEASED
2009-10-28
W6

DESIGN	<i>PH</i>	DART AEROSPACE LTD	
DRAWN	<i>RF</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PS</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>PS</i>	D412-664-243	SHEET 2 OF 4
APPROVED	<i>PS</i>	TITLE	SCALE
DE APPR.	<i>PS</i>	CROSSTUBE ASSEMBLY (412 HI AFT)	NTS
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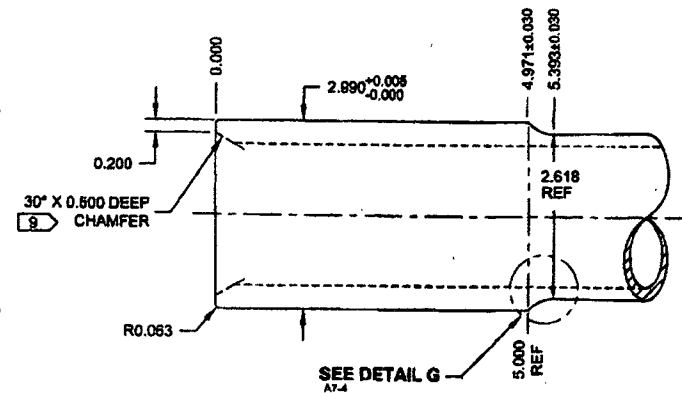
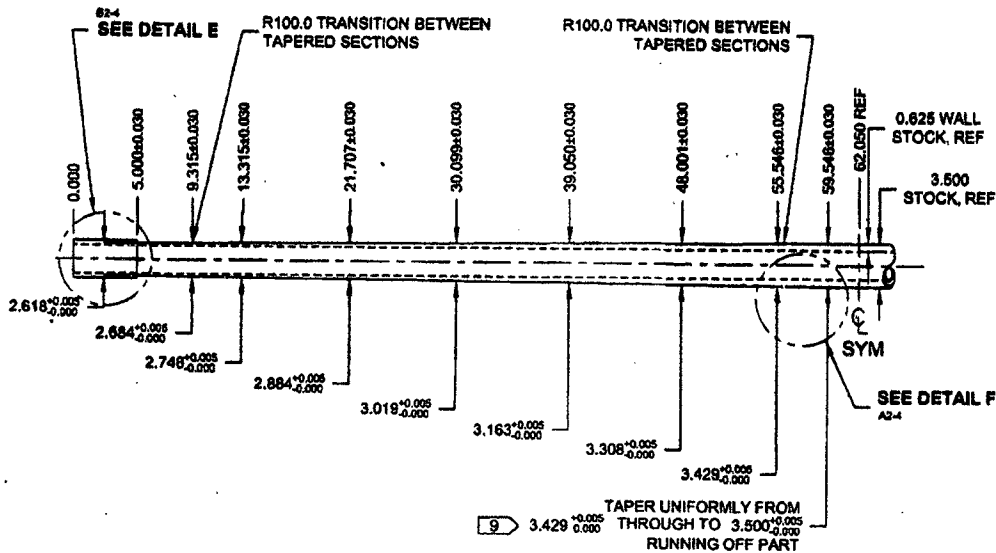


D412-664-603 10
BENDING AND DRILLING DETAIL E



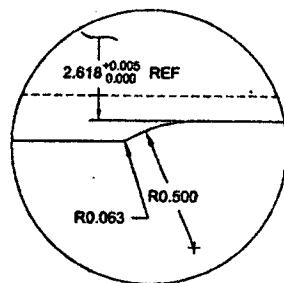
RELEASED
 2009-10-29
 MP

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PS	DRAWING NO.	REV. E
MFG. APPR.	PS	D412-664-243	SHEET 3 OF 4
APPROVED	PS	TITLE	SCALE
DE APPR.	PS	CROSSTUBE ASSEMBLY (412 HI AFT)	NTS
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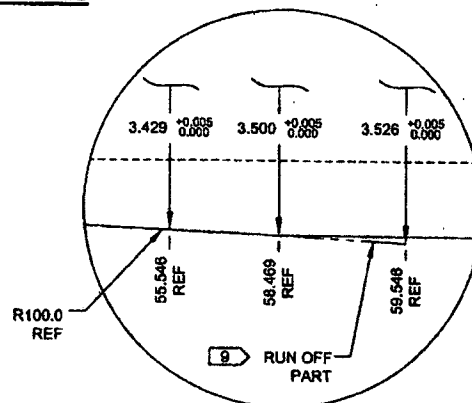


DETAIL E:
CROSSTUBE CUFF D8-4
SCALE 5X

D412-664-243TRN
TURNING DETAIL E



DETAIL G:
CUFF TRANSITION C2-4
SCALE 10X



DETAIL F:
TAPER RUN-OFF C4
NOT TO SCALE

RELEASED
2009-10-29
NTP

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	Q	DRAWING NO.	REV. E
MFG. APPR.	DS	D412-664-243	SHEET 4 OF 4
APPROVED	AP	TITLE	SCALE
DE APPR.	HA	CROSSTUBE ASSEMBLY (412 HI AFT)	NTS
DATE	09.09.30	COPYRIGHT © 2001 BY DART AEROSPACE LTD	



LIQUID PENETRANT TEST REPORT

P- 12234

CLIENT DMT AeroSpace DATE MARCH 30-2011 TIME AM ☒ PM ☐
ATTENTION LINDA LACELLE ACUREN JOB NO. 188-11-02067
ADDRESS 1270 ABERDEEN ST. POWO NO. 13743
HAWKES BURY ON. WORK LOCATION HAWKES BURY
K6A 1K7 ACCEPTANCE STD. ASTM 1417/051-038 REV./DATE 2005
PROJECT F.P.T. on CROSS TUBES & SLEEVES
ITEM(S) EXAMINED (6) (8)

JOB DESCRIPTION WET FLUORESCENT LIQUID PENETRANT INSPECTION PROCEDURE NO. LT-1012 REV./DATE 2008 TECHNIQUE NO. LT-1012 REV./DATE 2008
PART NO. — MATERIAL ALUMINUM THICKNESS VARIOUS
SCOPE CARRIED OUT ON 100% EXTERNAL SURFACE

TEST DETAILS
METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED
FAMILY BRAND MAGNA FLUX BLACK LIGHT S/N 16459 OUTPUT > 1000 μ W/cm² AMBIENT < 2 fc
PENETRANT ZL67 MINIMUM DWELL TIME 45 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER RD2 MINIMUM DRY TIME > 10 MIN. OTHER LABING
DEVELOPER SKD52 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N 1098866 CAL DUE DATE 06/19/2011
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

TEST SURFACE
SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☐ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE METAL
SURFACE TEMPERATURE ☐ < -4°C/ 20°F ☐ -4°C/ 20°F TO 10°C/ 50°F ☒ 10°C/ 50°F TO 52°C/ 125°F ☐ > 52°C/ 125°F

RESULTS- ☐ METRIC ☒ IMPERIAL

1	CROSS TUBE W.O. 67235	✓
1	CROSS TUBE W.O. 67236	✓
1	CROSS TUBE W.O. 67433	✓
8	SLEEVE W.O. 65346	✓
1	CROSS TUBE W.O. 67438	✓
1	CROSS TUBE W.O. 67437	✓
1	CROSS TUBE W.O. 67439	✓

PREVIOUS INDICATIONS FROM
MARCH 30-2011 - REPORT # P12233
ON THESE CROSSTUBES HAVE
BEEN REMOVED

AT 11-03-30

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES
CLIENT REPRESENTATIVE Linda Lacle DTR # E-63782
TECHNICIAN (SIGNATURE): Mike Johnston REPORT REVIEWED BY:
NAME (PRINT): Mike Johnston NAME INITIALS
1st TECHNICIAN 2nd TECHNICIAN
CGSB LEVEL 2 SNT LEVEL — CGSB LEVEL — SNT LEVEL —
CGSB REG. NO. 6606 CGSB REG. NO. —

Mike Petsche

From: dshepherd@dartaero.com
Sent: March 31, 2011 8:41 AM
To: Mike Petsche
Subject: Re: DSI for chafing shields

I am in favor of this change ... There is an email stuck in my outbox about it.

David

Sent from my BlackBerry device on the Rogers Wireless Network

From: "Mike Petsche" <mpetsche@dartaero.com>
Date: Thu, 31 Mar 2011 08:23:53 -0400
To: <mbellavance@dartaero.com>; 'David Shepherd' <dshepherd@dartaero.com>
Subject: DSI for chafing shields

David,

Bill mentioned that Falcon wasn't too keen on the abrasion strip under the chafing shield on the 412 crosstube. Apparently the use of Pro-seal was discussed in the telecon yesterday?

Bill would like it if we could ship the replacement crosstubes with this change already done. Marc can throw together a DSI. But before he does, fundamentally, are you in favour of this change?

MIKE PETSCHÉ
DART AEROSPACE
DESIGN MANAGER

613-632-5200
514-833-1657

5.0 PARTS LIST

5.1 HIGH GEAR CROSSTUBES

Item	-101	-201	-203	Part Number	Description
	X			D212-664-101	CROSSTUBE INSTALLATION, 204/205/210/212/214/412, UH-1H, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K HIGH FWD
		X		D212-664-201	CROSSTUBE INSTALLATION, 204/205/210/212/214, UH-1H, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K HIGH AFT
			X	D412-664-203	CROSSTUBE INSTALLATION, 412 HIGH AFT
1	1			D212-664-141	CROSSTUBE ASSEMBLY, 204/205/210/212/214/412, UH-1H, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K HIGH FWD
2		1		D212-664-241	CROSSTUBE ASSEMBLY, 204/205/210/212/214, UH-1H, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K HIGH AFT
3			1	D412-664-243	CROSSTUBE ASSEMBLY, 412 HIGH AFT
10	2			* D2893-1	SUPPORT
11	4			* D3595-063-450	RUBBER CUSHION
12	4			* MS21920-25	CLAMP (OR MS21042-26)
13	4			AN6-35A	BOLT
14	4			AN6-36A	BOLT
15	6			MS21042L6	NUT (OR MS21042-6)
16	18			AN960JD616	WASHER
20		2		* D2940-1	SUPPORT
21		4		* D3595-063-530	RUBBER CUSHION
22		4		* MS21920-28	CLAMP (OR MS21042-30)
23		4		AN6-40A	BOLT
24		2		AN6-41A	BOLT
25		6		MS21042L6	NUT (OR MS21042-6)
26		18		AN960JD616	WASHER
30			1	* D2896-1	SUPPORT
31			2	* D2856-600-1009	ABRASION STRIP
32			2	* D3595-063-570	RUBBER CUSHION
33			4	* MS21920-28	CLAMP
34			2	* MS21920-30	CLAMP (OR MS21042-32)
35			4	AN6-40A	BOLT
36			2	AN6-41A	BOLT
37			6	MS21042L6	NUT (OR MS21042-6)
38			18	AN960JD616	WASHER
39			2	* D3189-1	CHAFING SHIELD
50	1	1		D3428-1	PLACARD

*REFERENCE ONLY. PARTS ARE INCLUDED IN D212-664-141/-241 OR D412-664-243 ASSEMBLIES ABOVE
NOTE: KITS INCLUDE EXTRA HARDWARE FOR COMPATIBILITY WITH BOTH DART AND BELL/AA
SKIDTUBES.



Packing Slip: Return B

Ship From: Falcon Aviation
Al Bateen Airbase, Airport Road
Abu Dhabi, U.A.E.
Steve McComish
Tel #011 971 48860470

Ship To: Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada
Tel # 1.613.632.5200
GST # RT101272607

Date: April 16, 2012

P.O. #: Return

Ship Via: Journey

FOB:

Item	Part Number / Product Description	Qty. Ordered	Qty. Shipped	Qty. Back Order
1	D412-664-203 Crosstube Batch # 67434	1	1	0
2				
3				
4				
5				
6				
7	Parts Made In Canada being returned for evaluation			

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada
Tel.: 1.613.632.5200
Fax: 1.613.632.1185
GST # RT101272607

**Commercial Invoice: Return B**

Ship From: Falcon Aviation
Al Bateen Airbase, Airport Road
Abu Dhabi, U.A.E.
Steve McComish
Tel # 011 971 48860470

Ship To: Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada
Tel # 1.613.632.5200
GST # RT101272607

Date: April 16, 2012

P.O. #: Return

Ship Via: Journey

FOB:

Item	Part Number / Product Description	Tariff Class.	Quantity	Unit Price	Total
1	D412-664-203 Crosstube Batch # 67434	8803.20	1	\$ 9,972.00	\$ 9,972.00
2					\$ -
3				\$ -	\$ -
4				\$ -	\$ -
5				\$ -	\$ -
6				\$ -	\$ -
7	Parts being returned for evaluation			\$ -	\$ -

All Prices are in US Dollars
All of the above parts were made in Canada unless otherwise indicated
THIS IS A CUSTOMS INVOICE ONLY

Sub Total \$9,972.00

Total \$9,972.00

Amount Due: \$9,972.00

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